

Please cut ASAP.

Work Order ID 139055

139055

Friday, November 13, 2015 11:21:50 AM

Page 1

Item ID: D3067-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: End Plate

Start Date: 11/13/2015 Start Qty: 20.00

20

16056
54
609 56

Cust Item ID:

Required Date: 11/13/2015 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: NOV 17 2015

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3067

Rev A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3067

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

(56)

on 16/01/25

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

(56)

on 16/01/25

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.01

Quality Control

(56)

DAS
38
9-89

JAN 25 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

Work Order ID 139055***139055***

Friday, November 13, 2015 11:21:50 AM

Page 2

Item ID: D3067-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: End Plate

Stop

NS2

Start Date: 11/13/2015 Start Qty: 20.00

20

Cust Item ID:

Required Date: 11/13/2015 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Brake NC

NC BRAKE

0.00

Memo

0.00

DAS
30
9-89

56

JAN 25 2016

Brake NC

Bend as per Dwg D3067

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.01

DAS
38
9-89

56

JAN 26 2016

150

150

Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

*** STOCK IN STEP CELL ***
LOCATION: WA003

56

DAS
6
9-89

JAN 26 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Work Order ID 139055***139055***

Friday, November 13, 2015 11:21:50 AM

Page 3

Item ID: D3067-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: End Plate

Stop ***NS2***

Start Date: 11/13/2015 Start Qty: 20.00

20

Cust Item ID:

Required Date: 11/13/2015 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.03

Quality Control

ML5 JAN 27 2016

ML5 JAN 26 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Friday, November 13, 2015 11:21:49 AM

Page 1

Work Order ID: 139055

139055

Parent Item: D3067-1

D3067-1

Parent Item Name: End Plate

Start Date: 11/13/2015

Required Date: 11/13/2015

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP: 03.01.21 Remove step 6 (Deburr)

KJ

IPP Rev:B Now on Water jet 06-06-16 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.063		Purchased			No	100	sf	42.5849	0.0625	1.31579			

M5052H32S 063

5052-H32 .063 Sheet

**

on 16/01/25

Location

Loc Qty

Loc Code

MAT022

42.5849

M128455

10.5849

M133557

32

4.2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

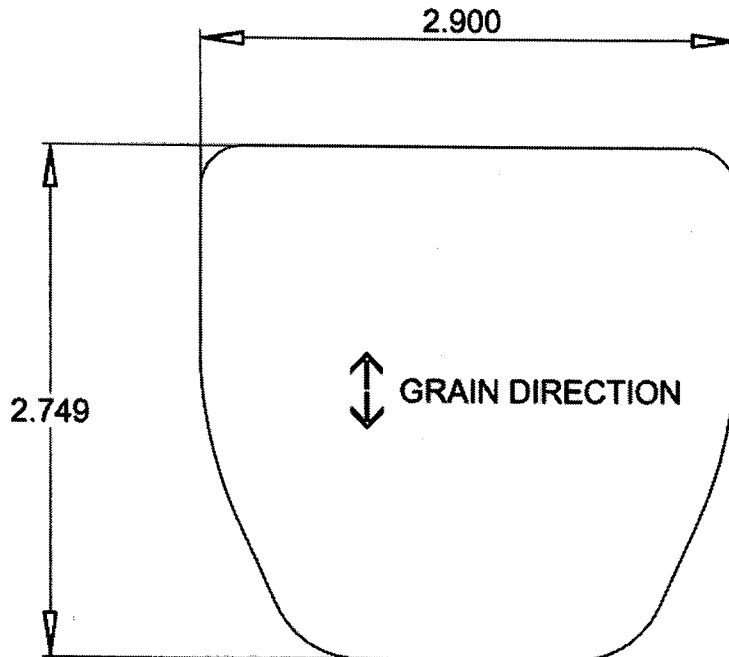
Work Order update only ☐

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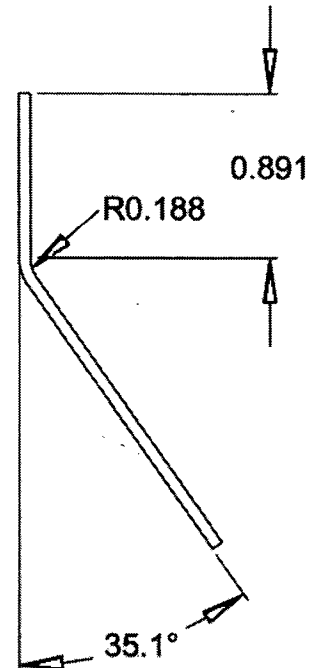


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>CP</i>	DRAWING NO. D3067	REV. A SHEET 1 OF 1
DATE 02.09.11		TITLE END PLATE	SCALE 1:1
A	02.09.11	NEW ISSUE	

RELEASED
02.09.2011



D3067-1 FLAT PATTERN



D3067-1 BEND DETAIL

D3067-1 END PLATE

- 1) MACHINE PER DWG FILE "D3067-1.SLDPRJT"
- 2) MATERIAL: 5052-H32 PER QQ-A-250/8 (REF DART SPEC. M5052H32S.063)
OR 6061-T6 PER QQ-A-250/11 (REF DART SPEC. M6061T6S.063)
ALUMINUM SHEET, 0.063 THICK
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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